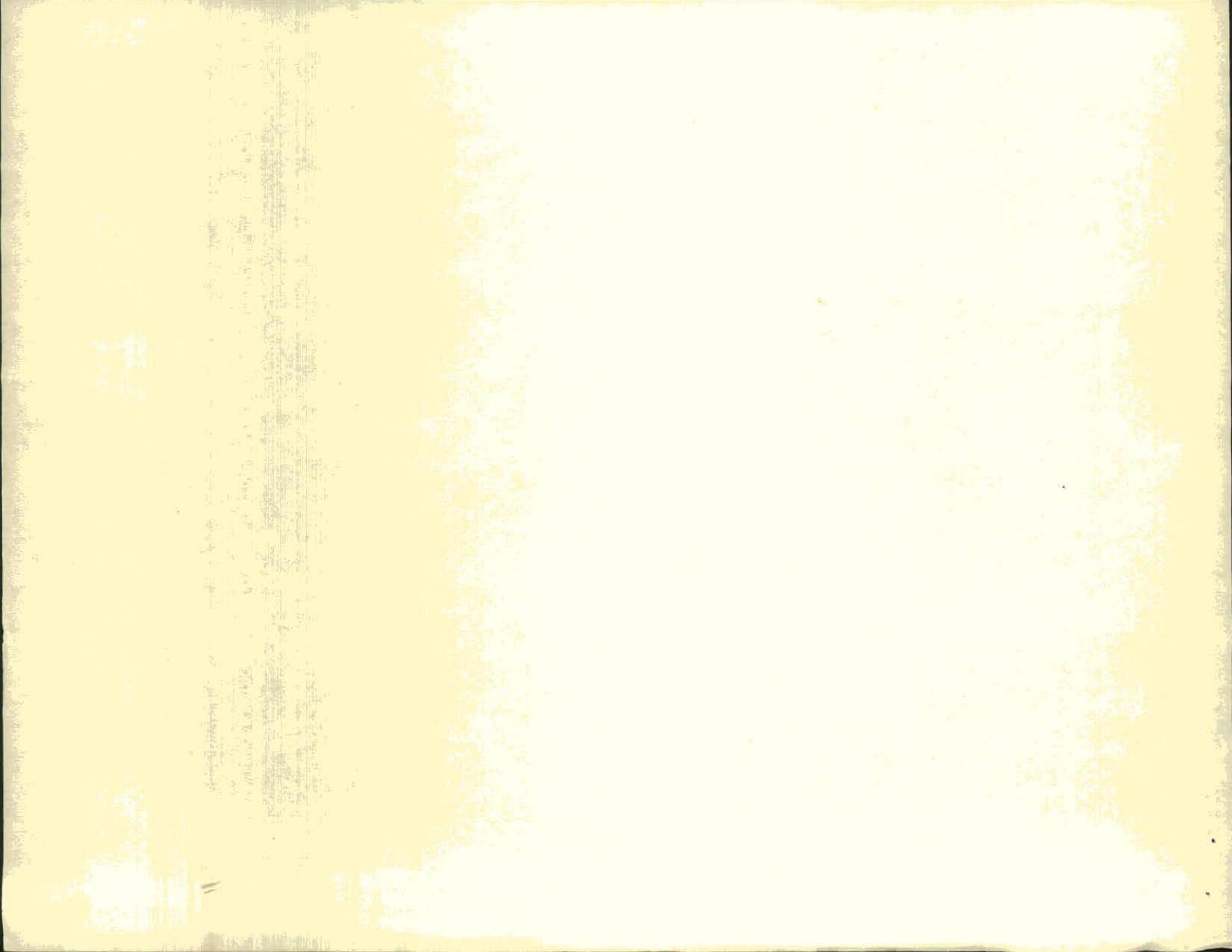


Split

Job Number : 32375 *2*
 Estimate Number : 10312
 P.O. Number : N/A
 This Issue : 5/16/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : PURCHASED PARTS
 Previous Run : 31335
 Written By : *John* Due Date : 6/5/2007 Qty: 16 Unit: Each
 Checked & Approved By : *John* 07.05.16
 Comment : Est: G 05.08.22 Hole size revised in Step 5 KJ/JLM
 Est Rev:H Changed Inserts 07.02.19 JLM

Additional Product

Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		Comment: PURCHASING Issue P/O: <i>3794</i> <i>07/05/16</i> (16)
		1-Spin as per Dwg D2646 2-Material release note required
2.0	D2646P	Att Cap
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s) AFT CAP
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached <i>07/06/05 (16)</i>
4.0	QC6	DIMENSIONAL CHECK
		Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D2646 <i>07/06/05 (16)</i>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Drill using DT8026 as per Dwg D2646. 2-Open holes to .250 and sink as per Dwg D2646. 3-Deburr <i>.197</i> <i>.02</i> <i>.07-06.11</i> <i>07/06/12 (16)</i>



Date: Wednesday, 5/16/2007 8:13:23 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 32375

Part Number: D2646

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 HAND FINISHING1



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005.4.1

11

07-06-13

16

7.0 SPRAY PAINTING



SPRAY PAINTING



Comment: SPRAY PAINTING

P/D: 4058 c207/06/27 ②

-PRIME

-PAINT DELFLEET BLUE

-CLEAR DELFLEET

8.0 QC14



INSPECT SPRAY PAINT

207-07-03 ②



Comment: INSPECT SPRAY PAINT

9.0 ALS71032130



Insert



Comment: Qty: 2.0000 Each(s)/Unit Total: 32.0000 Each(s)

* INSERT

Batch: M103618

18

10.0 SMALL FAB 1



SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

11) 07-07-04 ②

11.0 QC5



INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0 PACKAGING 1



PACKAGING RESOURCE #1

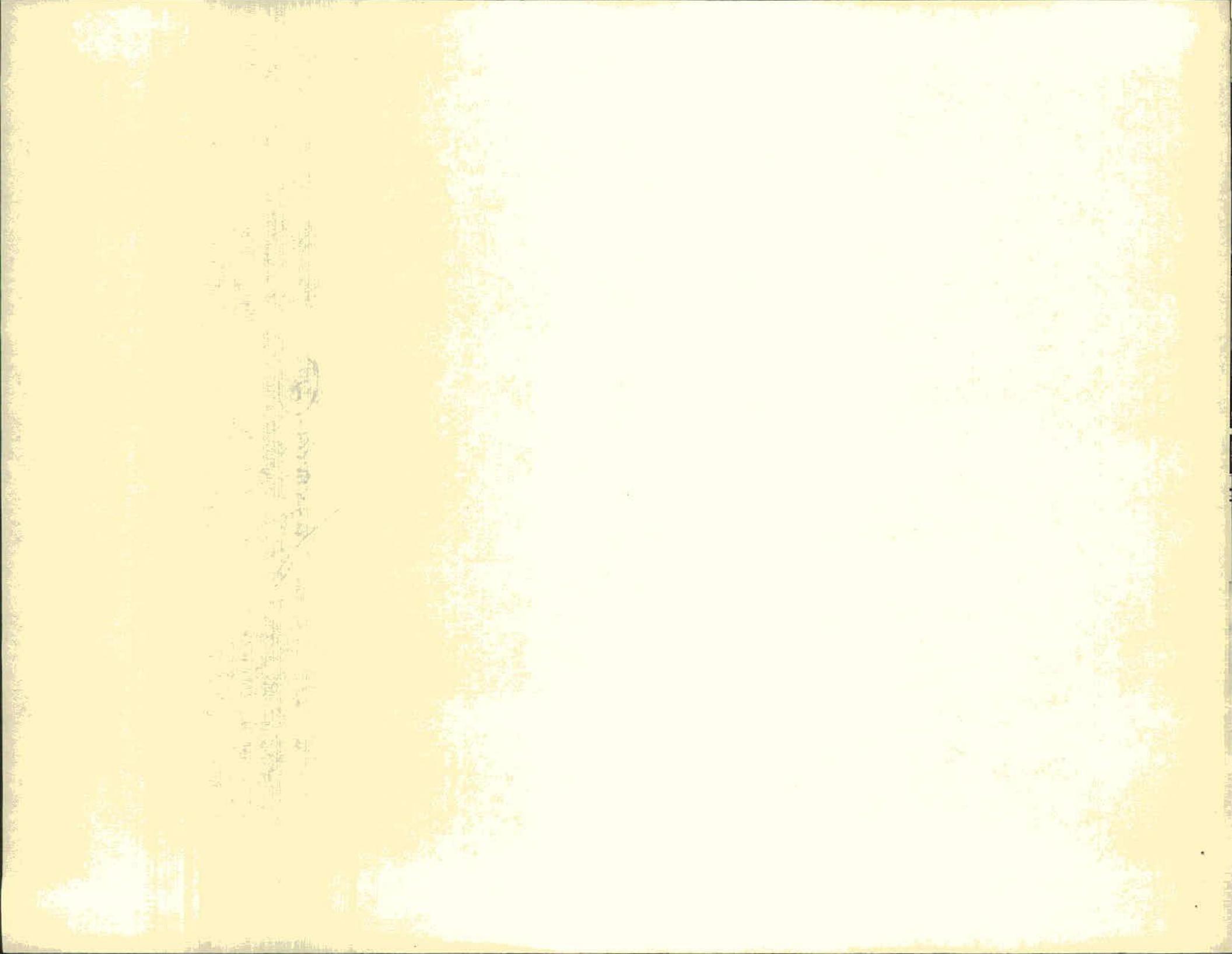


Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11) 09-07-04 ②



Date: Wednesday, 5/16/2007 8:13:23 AM
User: Kim Johnsen

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 32375

Part Number: D2646

Job Number



Seq. #: **Machine Or Operation:**

Description:

130

8021



FINAL INSPECTION/W/O RELEASE



2

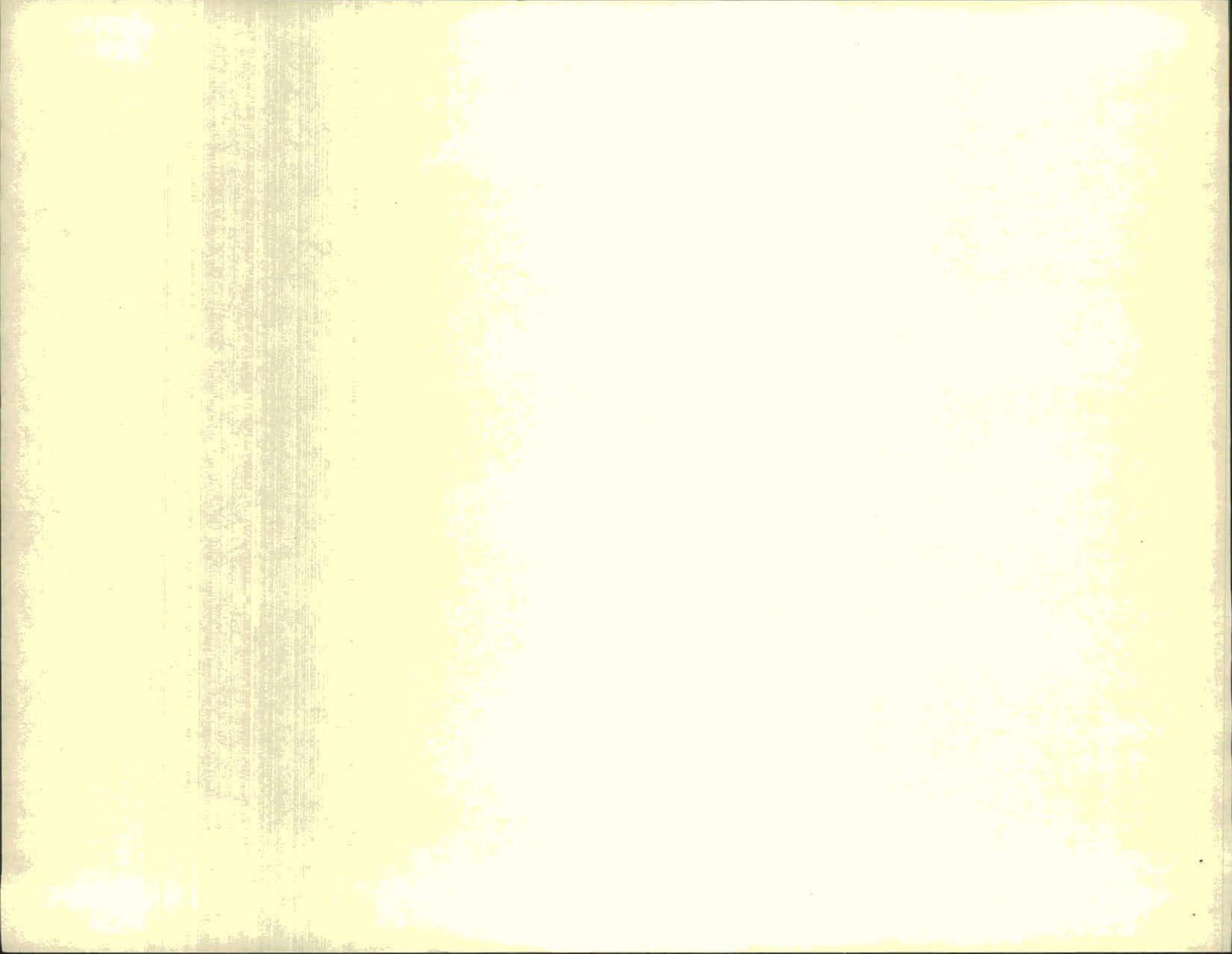
Comment: FINAL INSPECTION/W/O RELEASE

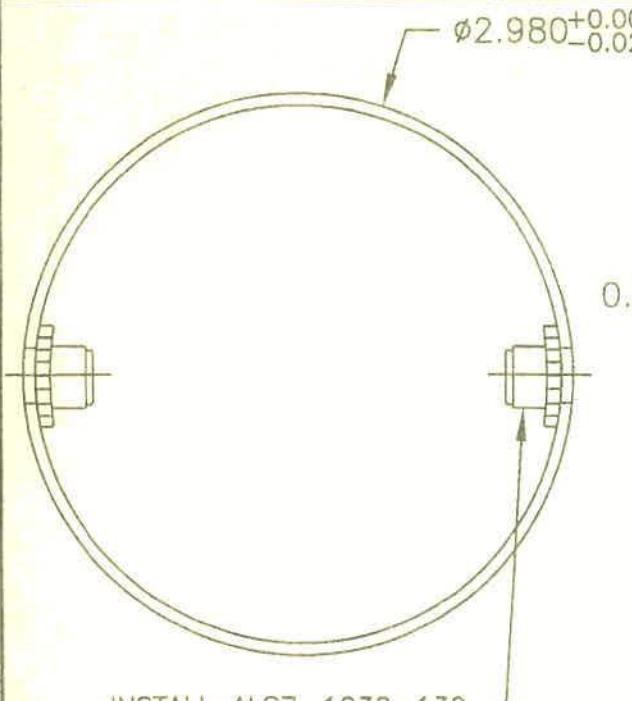
1 Dorothy

Job Completion

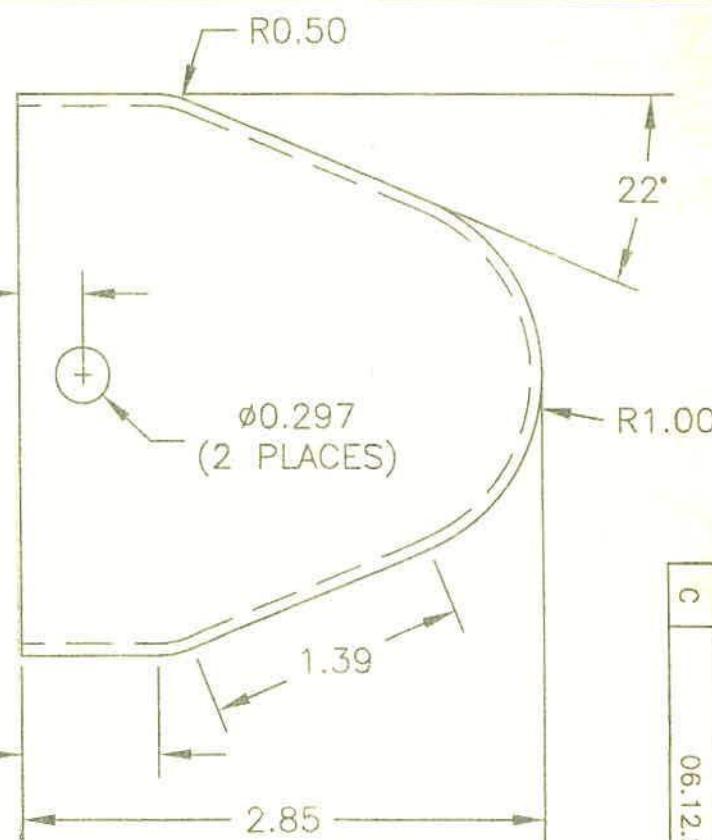


in 87.87.06



DART

INSTALL ALS7-1032-130
OR AKS4-1032-130
OR ALS4-1032-130
OR AELS-1032-130
INSERT AFTER FINISHING
(2 PLACES)



DESIGN	DS	DRAWN BY	DART AEROSPACE USA, INC.
		<i>PH</i>	PORT HADLOCK, WA
CHECKED		APPROVED	DRAWING NO. D2646
DATE			SHEET 1 OF 1
06.12.20	A	<i>PH</i>	TITLE AFT CAP
	B	<i>PH</i>	NEW ISSUE
	C	<i>PH</i>	05.04.01 CHANGE TO CLOSED INSERTS 06.12.20 CHANGE TO OPEN ENDED INSERTS

RELEASER
07.02.02

D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 32375
SHEET 1 OF 1
UNCONDITIONAL
SOLICITATION
WITH ACT NO.





1480 Manheim Pike
Lancaster Pa 17601

CERTIFICATION OF TEST RESULTS

SOLD TO
COPPER & BRASS SALES INC
22355 WEST ELEVEN MILK ROAD
SOUTHFIELD, MI 48034

SHIP TO
COPPER & BRASS SALES INC
6555 E DAVIDSON
DETROIT, MI 48212

CERT NO 0000598687
DATE 10/26/2004
SKID NO 322296
SKID WGT 9,760
PAGE 1 OF 1

ORDER NO	LB4176	PONO	C99792
ITEM NO	1	PART NO	050393-8
ALLOY	1100	TEMPER	O
GAUGE	.06300	WIDTH	48.0000
		LENGTH	0.0000

MILL FINISH
NOT ANODIZE QUALITY
OUT. STANDARD MILL FINISH
IN. STANDARD MILL FINISH
NOT EMBOSSED

LOT: 238066 COIL: B01 DROP: 440525

INCOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
440525/	0.11	0.42	0.08	6.02	0.002	0.001	0.014	0.001	0.02

HEAD ULTIMATE STRENGTH 12.2 KSI
TAIL ULTIMATE STRENGTH 12.6 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 4.9 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.6 KSI
HEAD ELONGATION (G.L. = 2 IN) 35.5 %
TAIL ELONGATION (G.L. = 2 IN) 33.5 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1291-04
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-02a

MECHANICAL AND CHEMICAL PROPERTIES MERT THE REQUIREMENTS OF
ASME SB209 1100 O, AMS 4001H 1100 O,
ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL
** END OF CERTIFICATION **

This document certifies the material above has been tested in accordance with applicable specifications described herein and has met those requirements. The material is subject to terms and conditions on the Alcoa sales order agreement.

Authorized By:

JOE FREDY, LAB SUPERVISOR

*John Henry P. Clark
Joe F.*



Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7
TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: June 4/07
Customer: Dart Aerospace
Packing Slip: 31273

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By
B32375	16 ✓	1461100	N/A	✓	RR
B32427	50	1461100	N/A	✓	RR

Notes:

Material Certification Attached: Yes.

